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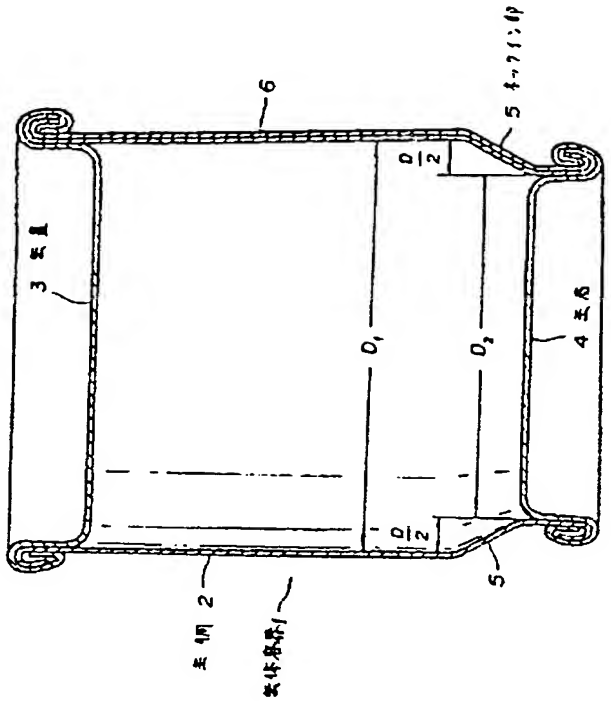
TITLE : MANUFACTURE OF CAN BODY CONTAINER



ABSTRACT : PURPOSE: To prevent the generation of wrinkles in the vicinity of the side seam part of a can shell by forming a neckin part on the can shell so that the necking amount of the can shell and the hardness of a can shell forming material may become within a forming range found experimentally.

CONSTITUTION: A can body container 1 is made by fastening a can cover 3 and can bottom 4 to both opening ends of the can shell 2 where a nickin part 5 is formed. In this case, the hardness of the steel material for can shell 2 is adjusted according to the necking amount D expressed by the diameter difference D_1~D_2 in the part not subjected to necking of the can shell 2 and the part subjected to necking. In case of the necking amount D being ≤2.8mm and ≤8.0mm, the steel stock coming within the range of $50\sim75.0\times D^{-0.181}$ hardness in Rockwell hardness HR30T is used. Also in case of the necking amount being ≤2.8mm, the steel stock coming within the range of 50~76 hardness in Rockwell hardness HR30T is used. The wrinkle generation in the vicinity of a side seam part can thus be prevented.